

Day, 28/04/2009 2:21:10 PM
Lacelle

Process Sheet

CU-DAR001 Dart Helicopters Services Drawing Name : HELI-UTILITY BASKET RH
 Number : 47573
 Estimate Number : 12433
 P.O. Number :
 This Issue : 28/04/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : LARGE FAB ASSY
 Previous Run : 47572
 Part Number : D205541044
 Drawing Number : IIN D205-541 REV G
 Project Number :
 Drawing Revision : G
 Material :
 Due Date : 05/05/2009 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : JUD 09.04.28
 Comment : Est Rev:C Re-Format 02-08-30 KJ
 Est Rev:D chg to revG Ecn 1157 08-03-19 DD verified by:

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL



for JUD 09/05/12



Comment: Photocopy bluefile & type labels per PPPD205-541-044 CHG002 8 09/05/12

2.0	47573A	350/212/130 BASKET LID
-----	--------	------------------------



Comment: Sub-Component 350/212/130 BASKET LID
 1 x D2512 Batch 47573A

BR 09-05-11

3.0	47573B	212 BASKET BASE ASS'Y RH
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Comment: Sub-Component 212 BASKET BASE ASS'Y RH
 1 x D3053-042 Batch 47573B

BR 09-05-11

4.0	D2022101	Spacer
-----	----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Spacer
 Batch: B41928

SS 09/05/11 (X)

5.0	D2258300	Label
-----	----------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Placard
 Batch: 42011

SS 09/05/11 (X)

Date: Tuesday, 28/04/2009 2:21:10 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET RH

Job Number: 47573

Part Number: D205541044

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D2332041	Lid Prop Assembly 6.69" long
-----	----------	------------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lid Prop Assembly 6.69"

Batch: _____

45682

SS 09105/11 (X)

7.0	D2530	Handle Weldment
-----	-------	-----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle Weldment

Batch: _____

46574

SS 09105/11 (X)

8.0	D2535	Spring
-----	-------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spring

Batch: _____

B45389

SS 09105/11 (X)

9.0	D2537	Bushing
-----	-------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

Batch: _____

45662

SS 09105/11 (X)

10.0	D2931	Bumper
------	-------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bumper

Batch: _____

21139

SS 09105/11 (X)

11.0	AN316A	Bolt
------	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: _____

M109798

SS 09105/11 (X)

12.0	AN47A	Bolt
------	-------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: _____

110155

SS 09105/11 (X)

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Drawing Name: HELI-UTILITY BASKET RH

Job Number: 47573

Part Number: D205541044

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M167715

SS 09105/11 (X)

14.0

AN424A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M108255

SS 09105/11 (X)

15.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M116625

SS 09105/11 (X)

16.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M110363

SS 09105/11 (X)

17.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M110153

SS 09105/11 (X)

18.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: M110523

SS 09105/11 (X)

19.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M110382

SS 09105/11 (X)

Date: Tuesday, 28/04/2009 2:21:10 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET RH

Job Number: 47573

Part Number: D205541044

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: M111724

9/5/11

21.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M110844

8/9/05/11 (K)

22.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M110450

8/9/05/11 (K)

23.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M109840

8/9/05/11 (K)

24.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cherry Rivets

Batch: M106375

8/9/05/11 (K)

25.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg.

BL 04-05-11 (D)

26.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5/9/05/12 (K)

Date: Tuesday, 28/04/2009 2:21:10 PM
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Process Sheet

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Drawing Name: HELI-UTILITY BASKET RH

Job Number: 47573

Part Number: D205541044

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

28.0

D21991

Strut Details



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Struts, 19"
Batch: 43596

29.0

D219923

Strut Details



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Strut
Batch: 40195

30.0

D219925

Strut Details



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Strut
Batch: 43597

31.0

D2498

Mounting Bracket, 205 Basket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Mounting Bracket
Batch: 37542

32.0

D2499

Mounting Bracket, 205 Basket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Mounting Bracket
Batch: 37543

33.0

D2515

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bushing
Batch: 29138

Date: Tuesday, 28/04/2009 2:21:10 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET RH

Job Number: 47573

Part Number: D205541044

Job Number:



Seq. #:	Machine Or Operation:	Description :
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34.0	D30521	Mounting Lug
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Mounting Lug

Batch: 46200

SS 09/05/12 (X)

35.0	AN47A	Bolt
------	-------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: 110155

SS 09/05/12 (X)

36.0	AN412A	Bolt
------	--------	------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bolt

Batch: M109754

SS 09/05/12 (X)

37.0	AN413A	Bolt
------	--------	------



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Bolt

Batch: M111477

SS 09/05/12 (X)

38.0	AN414A	Bolt
------	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M107534

SS 09/05/12 (X)

39.0	AN57A	Bolt
------	-------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M110625

SS 09/05/12 (X)

40.0	AN513A	Bolt
------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M110363

SS 09/05/12 (X)

Date: Tuesday, 28/04/2009 2:21:10 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET RH

Job Number: 47573

Part Number: D205541044

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

AN960JD416

Washer



Comment: Qty.: 29.0000 Each(s)/Unit Total: 29.0000 Each(s)
Washer
M110363

SS 09/05/12 (X)

42.0

AN960JD516

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)
Washer
Batch: M110523

SS 09/05/12 (X)

43.0

MS21042L4

Nut



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)
Nut
Batch: M110450

SS 09/05/12 (X)

44.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Nut
Batch: 109840

SS 09/05/12 (X)

45.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

SS 09/05/12 (X)

46.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D205-541-044
Location: F
PPP Rev: F

SS 09/05/12 (X)

47.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SS 09/05/12 (X)

Job Completion



U 09.05.12

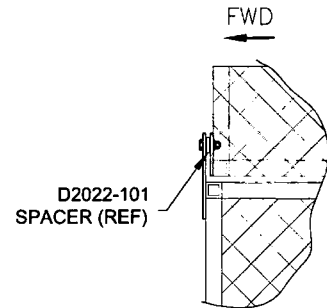
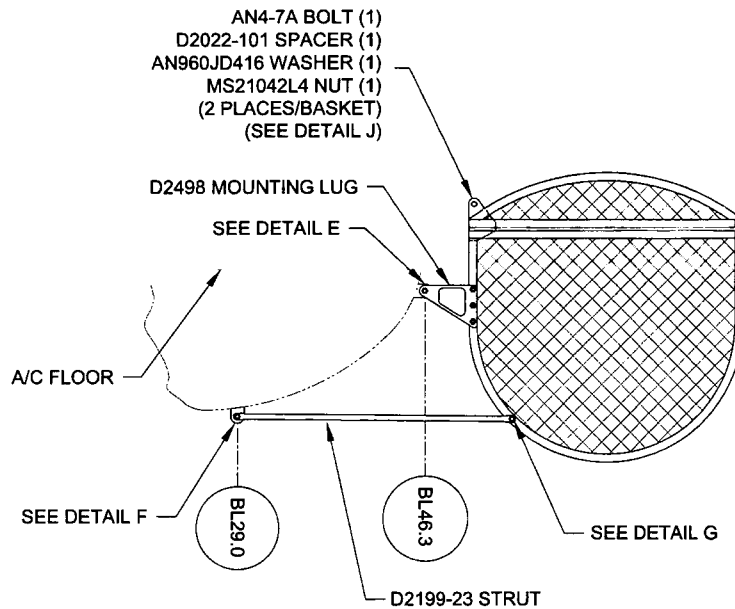
5.0 PARTS LIST HELI-UTILITY-BASKET™

Qty -043	Qty -044	Qty -045	Qty -046	Part Number	Description
X				D205-541-043	HELI-UTILITY-BASKET, LH
	X			D205-541-044	HELI-UTILITY-BASKET, RH
		X		D205-541-045	HELI-UTILITY-BASKET, LH
			X	D205-541-046	HELI-UTILITY-BASKET, RH
2*	2*			D2022-101	SPACER
1	1	1	1	D2199-1	STRUT
1	1	1	1	D2199-23	STRUT
1	1	1	1	D2199-25	STRUT
1*	1*	1*	1*	D2258-300	LABEL
1*	1*	1*	1*	D2332-041	PROP ASSEMBLY
1	1	1	1	D2498	MOUNTING LUG
1	1	1	1	D2499	MOUNTING LUG
1*	1*			D2512	BASKET LID ASSEMBLY
2	2	2	2	D2515	BUSHING
1*	1*	1*	1*	D2530	HANDLE ASSEMBLY
2*	2*	2*	2*	D2535	SPRING
2*	2*	2*	2*	D2537	BUSHING
2*	2*			D2931	BUMPER
1	1	1	1	D3052-1	MOUNTING LUG
1*				D3053-041	BASKET BASE ASSEMBLY, LH
	1*			D3053-042	BASKET BASE ASSEMBLY, RH
		1*		D3712-041	BASKET BASE
			1*	D3712-042	BASKET BASE
		1*		D3713-041	LID ASSEMBLY
			1*	D3713-042	LID ASSEMBLY
		6*	6*	D3723-1	BUSHING
2*	2*	2*	2*	AN3-16A	BOLT
2*	2*			AN4-7A	BOLT
2	2	2	2	AN4-7A	BOLT
3	3	3	3	AN4-12A	BOLT
9	9	9	9	AN4-13A	BOLT
2	2	2	2	AN4-14A	BOLT
		3*	3*	AN4-20A	BOLT
1*	1*	1*	1*	AN4-22A	BOLT
1*	1*	1*	1*	AN4-24A	BOLT
1	1	1	1	AN5-7A	BOLT
1	1	1	1	AN5-13A	BOLT
4*	4*	4*	4*	AN5-17A	BOLT
2*	2*	6*	6*	AN960JD416	WASHER
27	27	27	27	AN960JD416	WASHER
2*	2*	2*	2*	AN960JD416L	WASHER
4*	4*	4*	4*	AN960JD516	WASHER
3	3	3	3	AN960JD516	WASHER
2	2			AN960JD8	WASHER
4*	4*	4*	4*	AN970-4	WASHER

...CONTINUED ON NEXT PAGE

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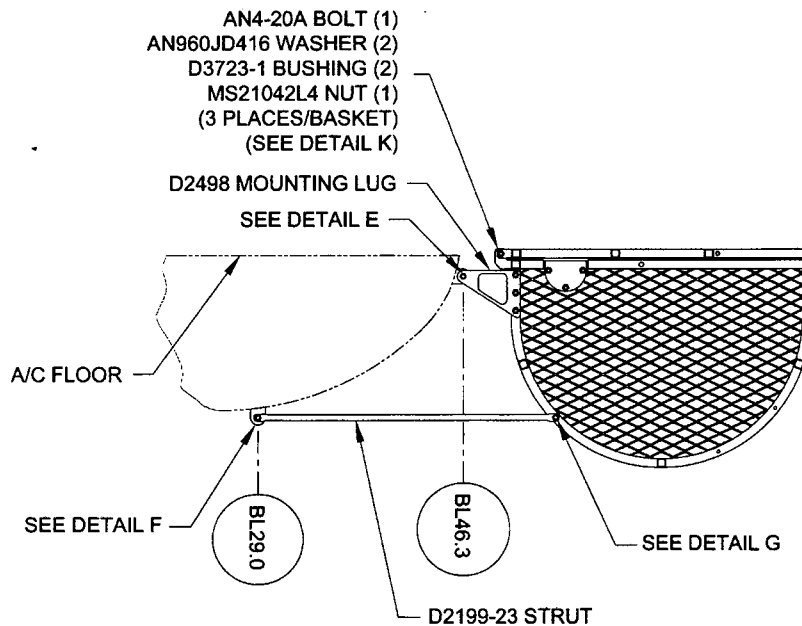
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 ENGINEERING
 WITHOUT NOTICE
 Revision: 6
 Date: 08/03/04
 NO. 47157



DETAIL J
HINGE DETAIL:
SIDE VIEW, LOOKING OUTBOARD.
OTHER END OPPOSITE

Figure 2a - Section A-A Looking Fwd at STA 84.29

(D205-541-044 Shown; D205-541-043 Opposite)



REFERENCE ONLY
#47573

DETAIL K
HINGE DETAIL:

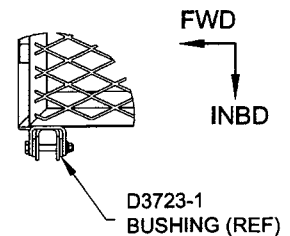


Figure 2b - Section A-A Looking Fwd at STA 84.29

(D205-541-046 Shown; D205-541-045 Opposite)

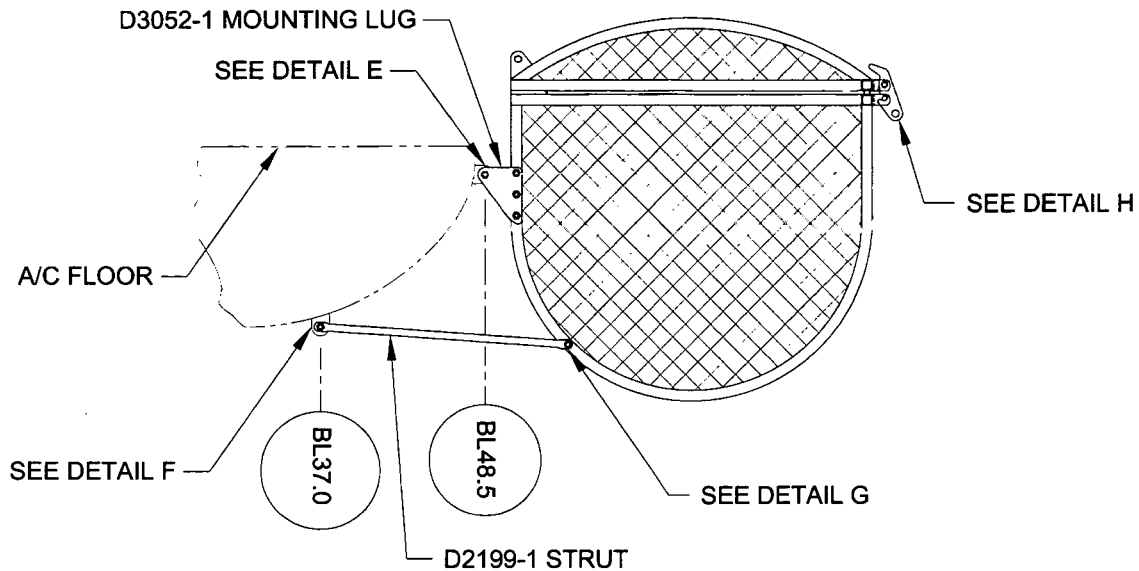


Figure 3a – Section B-B Looking Fwd at STA 129.00
(D205-541-044 Shown; D205-541-043 Opposite)

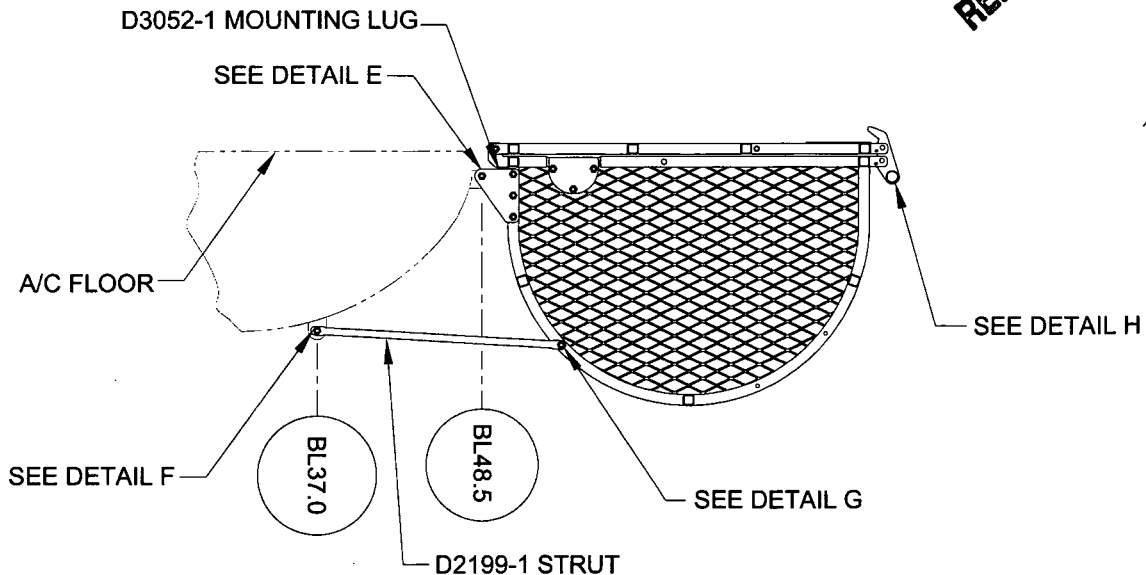


Figure 3b – Section B-B Looking Fwd at STA 129.00
(D205-541-046 Shown; D205-541-045 Opposite)

REFERENCE ONLY

#47573

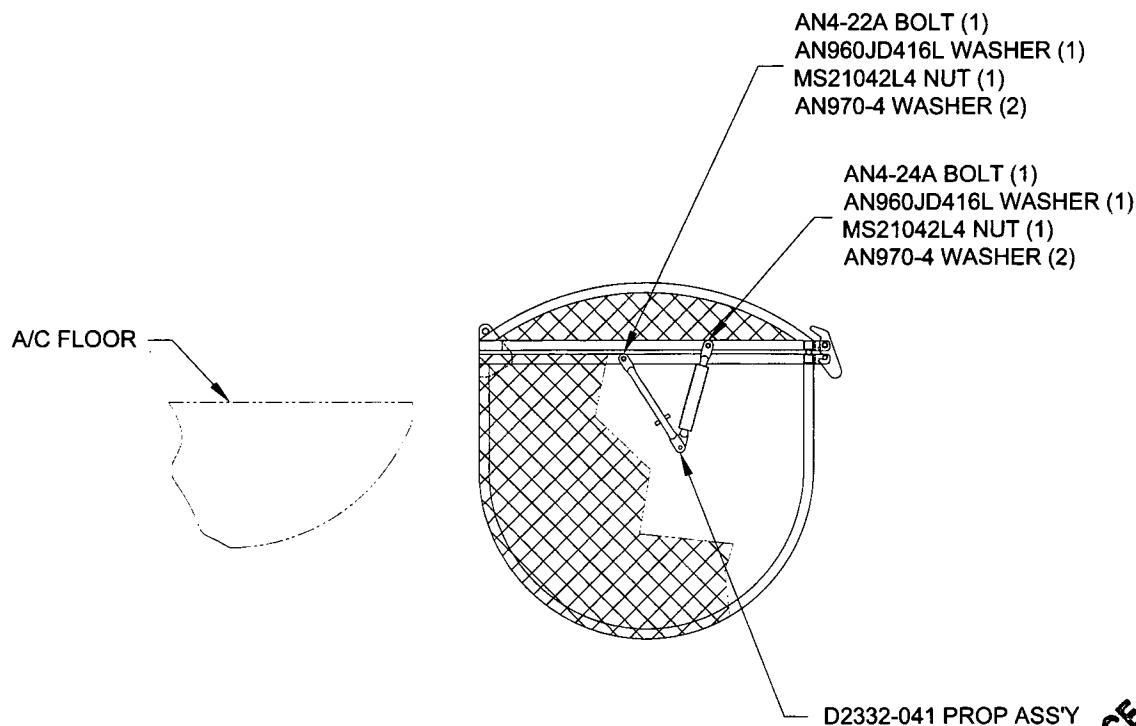


Figure 5a – Section D-D Looking Fwd at STA 180.08
(D205-541-044 Shown; D205-541-043 Opposite)

REFERENCE ONLY
#47573

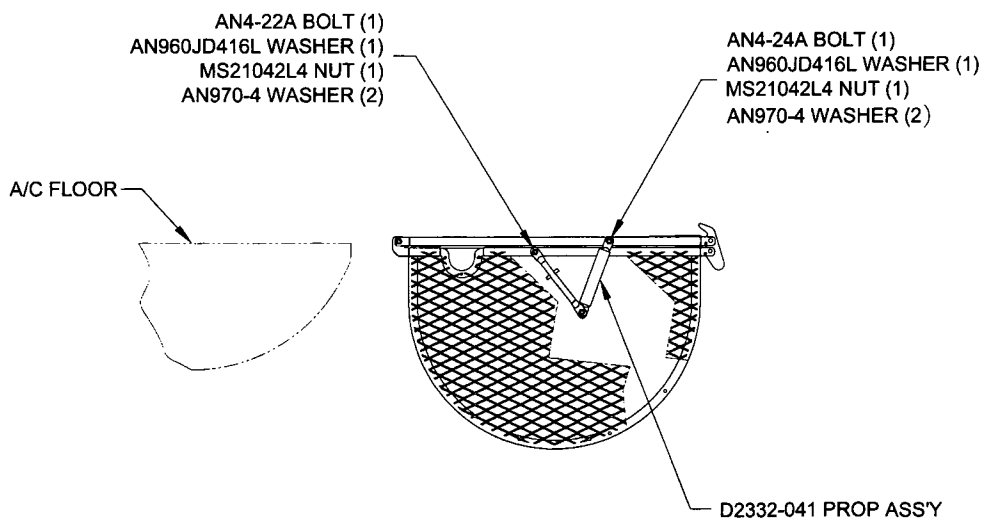


Figure 5b – Section D-D Looking Fwd at STA 180.08
(D205-541-046 Shown; D205-541-045 Opposite)

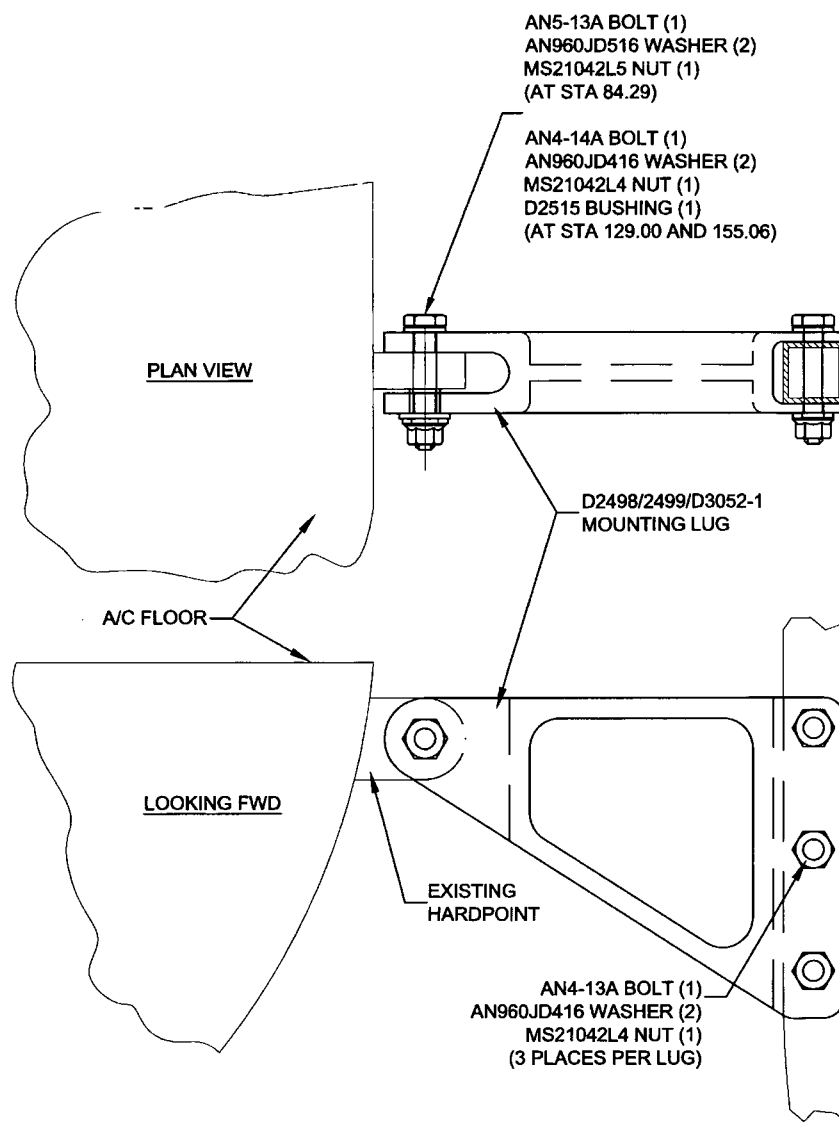


Figure 6 – Detail 'E' Mounting Lug Installation

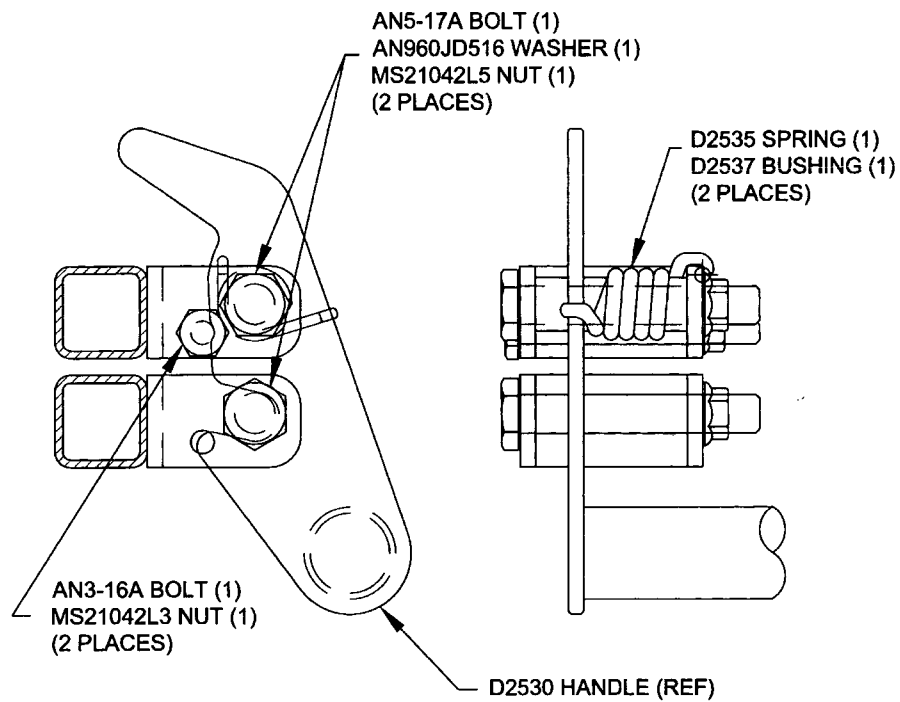


Figure 9 - Detail 'H' Handle Assembly

REFERENCE ONLY

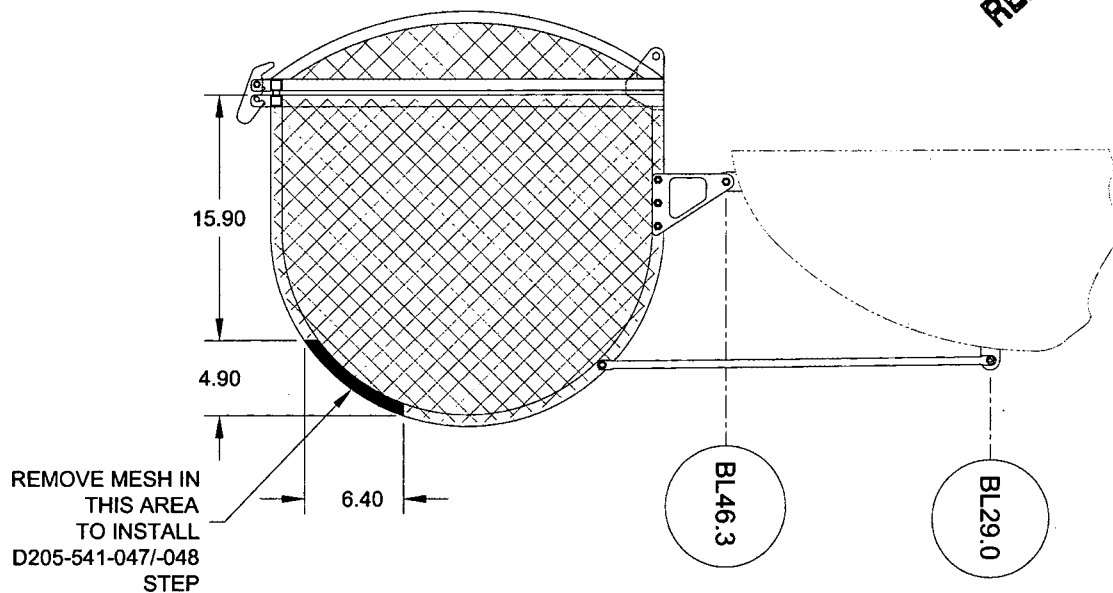


Figure 10 - Mesh Removal Looking Aft at STA 84.00
(D205-541-044 Shown; D205-541-043 Opposite)